

Date: Wednesday, 15/10/2008 8:16:55 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SQUARE TUBE
Job Number : 42603	
Estimate Number : 13420	
P.O. Number :	Part Number : PB6743001207
This Issue : 15/10/2008 S.O. No. :	Drawing Number : B6743001 P.5/ P.16
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B1
Previous Run : 40593	Material :
Written By :	Due Date : 15/10/2008 Qty: 3 Um: Each
Checked & Approved By : <u>MF 08-10-15</u>	
Comment : Est Rev:A 08-06-26 new issue DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6TS1000W120	6061T6 SQ TUBE 1.00 x 1.00 X .120w



Comment: Qty.: 1.9469 f(s)/Unit Total: 5.8407 f(s)
6061T6 SQ TUBE 1.00X.120
batch: M109057

SAD 08/10/15

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- cut to length as per dwg
- 2- make a 0.090" chamfer on both ends of tube
- 3- deburr

SAD 08/10/15

(3)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SAD 08/10/15 (43)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

- 1- drill holes as per dwg
- 2- make a 0.090" chamfer (100 degree) on both side of the 4 holes
- 3- deburr

SAD 08/10/15

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SAD 08/10/15 (43)

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Drawing Name: SQUARE TUBE

Job Number: 42603

Part Number: PB6743001207

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001225

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bushing

batch: *B40272*

SP

08.10.15

(3x)

7.0

PB6743001223

Square Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Square Cap

batch: *3 42604*

SP

08.10.15

(3x)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg

SP 08.10.15

(3x)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush

2- deburr

SP 08.10.15

3x

10.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/16

(42)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/16

(42)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *CARL welding*

S 08/10/16

(42)

13.0

QC21

FINAL INSPECTION/W/O RELEASE

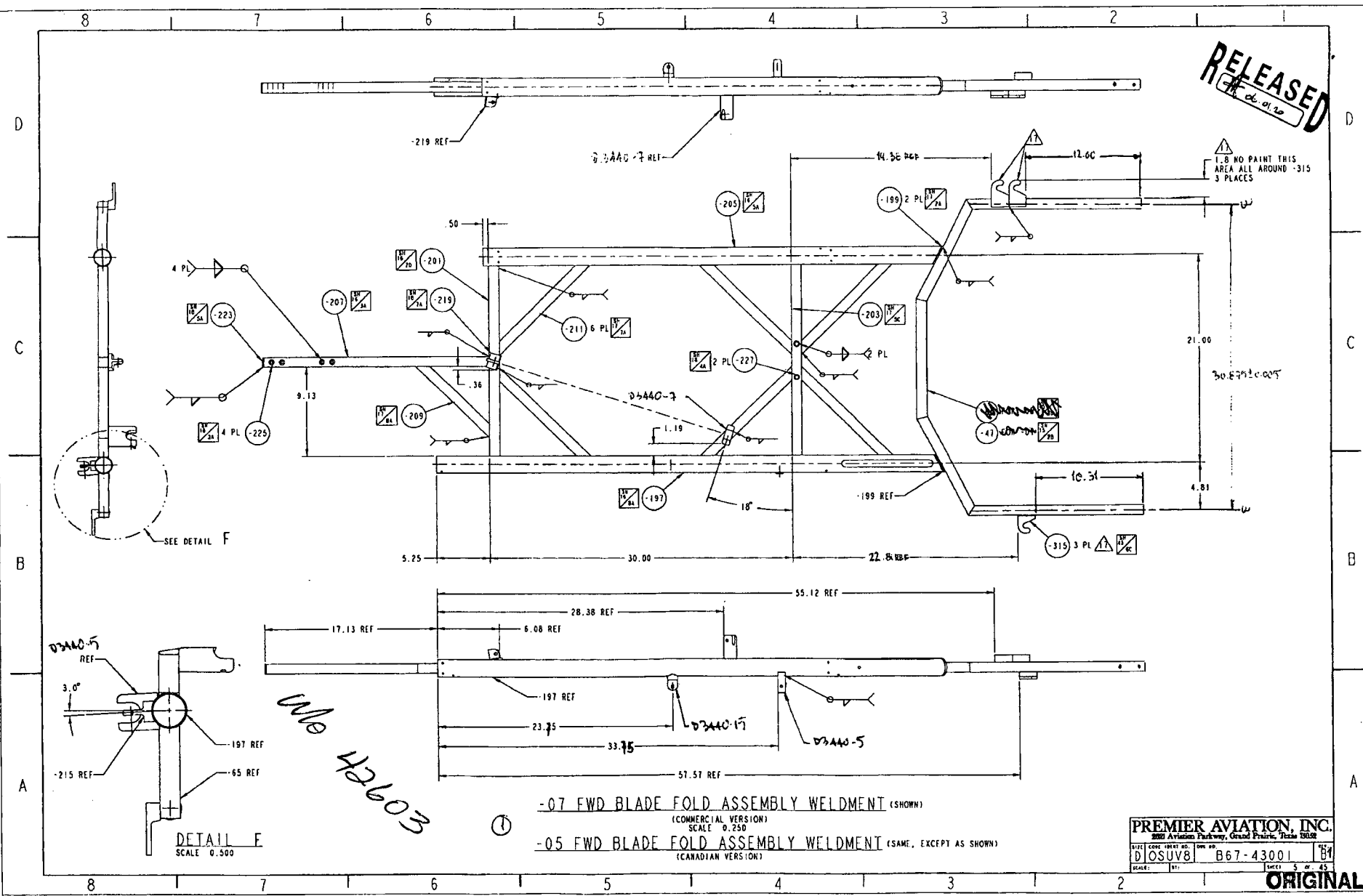


Comment: FINAL INSPECTION/W/O RELEASE

08/10/16

mf 08-10-16

RELEASED
06-01-20



ORIGINAL

